

Date: Thursday, 2/14/2008 10:57:45 AM
User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	PATIENT STOP		
Job Number	37434		Part Number	D2492		
Estimate Number	11490		Drawing Number	D2492 REV F		
P.O. Number			Project Number	N/A		
This Issue	2/14/2008	S.O. No.	Drawing Revision	F		
Prsht Rev.	NC		Material			
First Issue	/ /	Type	Due Date	2/25/2008	Qty:	10
Previous Run	36243		Um:	Each		
Written By	<u>JLJ 080214</u>					
Checked & Approved By						
Comment	Est. E 00-06-26 Removed P/O for powder coat EC Est Rev:F Now 6061-T6 06-06-23 JLM Est Rev:G now water jet 07-12-11 DD					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6S080	6061-T6 .080 Sheet Comment: Qty.: 1.9140 sf(s)/Unit Total : 19.1405 sf(s) 6061-T6 .080 Sheet Material: 6061-T6 0.080" thick (M6061T62S.080) Batch <u>107276</u> <u>B 8-3-S</u> 10
2.0	WATER JET	FLOW WATER JET Comment: FLOW WATER JET 1-Cut as per Dwg D2492 Dwg Rev: <u>F</u> <u>B 8-3-S</u> Prog Rev: <u>F</u> 2-Deburr if necessary <u>B 8-3-S</u>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE <u>B 8-3-S</u> Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK Comment: SECOND CHECK 08/08/08 (AO)

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/14/2008 10:57:46 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: PATIENT STOP
Job Number: 37434		Part Number: D2492
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
5.0	BRAKE NC	NC BRAKE 
Comment: NC BRAKE Deburr Form using Jig DT2492B		
6.0	QC5	INSPECT WORK TO CURRENT STEP. 
Comment: INSPECT WORK TO CURRENT STEP		
7.0	HAND FINISHING1	HAND FINISHING RESOURCE #1 
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1		
8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION 
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		
9.0	POWDER COATING	POWDER COATING 
Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3		
10.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION 
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		
11.0	PACKAGING 1	PACKAGING RESOURCE #1 
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: PIP Y1338		
12.0	QC21	FINAL INSPECTION/W/O RELEASE 
Comment: FINAL INSPECTION/W/O RELEASE		
Job Completion		
MF 08-10-31		

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

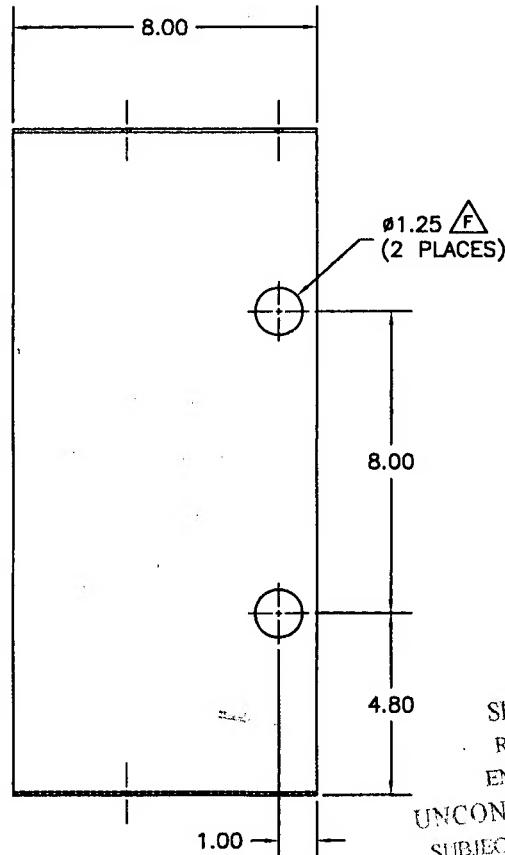
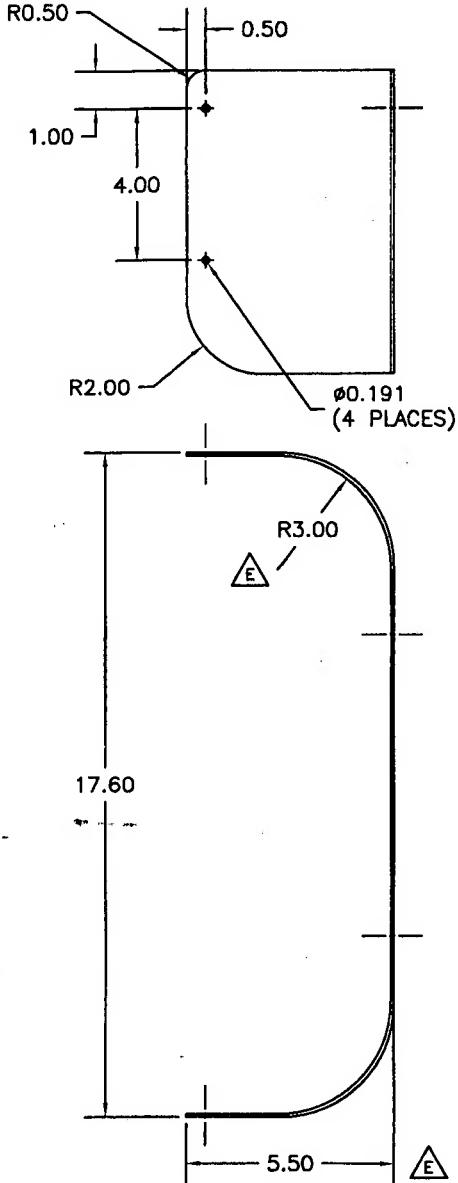
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN KE	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2492
DATE 06.09.14	TITLE PATIENT STOP	REV. F SHEET 1 OF 1 SCALE 1:5
A	95.10.24	NEW ISSUE
B	96.02.28	MINOR CHANGES
C	97.07.14	CHANGED MATERIAL AND FINISH
D	98.05.11	R4.00 WAS R2.00 ADDED 8" WIDTH DIMENSION
E	06.05.30	ADD 6061-T6 MATERIAL, R3.0 WAS R4.00, 5.50 WAS 6.00
F	06.09.14	Ø1.25 WAS Ø1.020



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *37434*

D2492 PATIENT STOP

- 1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK
(REF DART SPEC M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

RELEASED

06.09.14

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DART AEROSPACE LTD	Work Order:	37434
Description: PATIENT STOP	Part Number:	D2492
Inspection Dwg:D2492 Rev: F		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X

First Article

1

Prototype

Measured by:	FB	Audited by:		Prototype Approval:	/
Date:	8-3-5	Date:	28/3/05	Date:	/

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	